

3/27/2018

[Dart Hawkesbury] Job Sheet - David, Logan



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RB8813152000
Job Sheet 175103



Part No: RB8813152000

Job Qty: 3 ea

Part Name: Rear Bearing Tool



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 3/27/18

Job Tracking No:

Due Date: 4/2/18

Created By: Logan David

Type: SOLD

Description:

Note: DWG RB8813152000 Rev A IPP Rev A 18.01.26 New issue DP Verify DD/IPP Rev B drawing revision
18.03.27 DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea		3/31/18	0.00	0.00	Start Up Handfinish	W	
110	HandFinish	3 pcs		3/31/18	0.00	0.30	HandFinish7		BEB 18-03-28
120	Mill Conv	3 pcs		3/31/18	0.00	3.00	Mill Conv 2		J.C.L.
130	QC	3 pcs		3/31/18	0.00	0.00	QC2 Machining-5		J.C.L. 18-04-16
131	Mori Seiki	3 pcs		3/31/18	0.00	0.75	MORI NV5000-1	FCG19	A 18-04-11
132	QC	3 pcs		3/31/18	0.00	0.00	QC2 Machining-2		A 18-04-11
140	QC	3 pcs		3/31/18	0.00	0.00	QC8 Machining-3		18-04-11
150	Small Fab	3 pcs		3/31/18	0.00	0.00	Small Fab-5		EL
160	QC	3 pcs		3/31/18	0.00	0.00	QC5		EL
170	Large Fab	3 pcs		4/2/18	0.00	0.75	Large Fab 1		18-04-11
180	QC	3 pcs		4/2/18	0.00	0.00	QC9		18-04-12
190	Outsource	3 pcs		4/2/18	0.00	0.00	Outsource13		18-04-19
200	Packaging	3 pcs		4/2/18	0.00	0.00	Packaging2		18-04-20
210	QC	3 pcs		4/2/18	0.00	0.00	QC6		GA139
220	Packaging	3 pcs		4/2/18	0.00	0.00	Packaging3 Large Fab		
230	QC21-FG	3 Ea		4/2/18	0.00	0.00	QC21		

Part Op 110 - Bead blast, remove all chrome from the 17mm wrench. On the 19mm wrench remove chrome only on 19mm end.
Descriptions: See drawing for more details.

120 - Machine 19mm. wrench as per DWG.

131 - Remove factory markings and engrave tool number on 17mm wrench.

150 - 1-Cut and form 17mm wrench as per DWG. 2-Cut 19mm. wrench as per DWG. 3-Deburr

170 - Weld 19mm wrench to 17mm wrench as per DWG.

190 - Issue P/O to Groupe Altech: P/O 039590 -Zinc plate, ASTM B633 TYPE 2 SC2 -Color yellow -Certificate of Conformity is required

220 - Bag and tag

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
54855A35	Open End Wrench, 17mm	3 Ea (1 ea)	90-Start up Operation	
54855A37	Open End Wrench, 19mm	3 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	54855A35	3	6	0
	54855A37	3	9	0

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3/27/2018

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Part Specifications

Specifications could not be found.

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Container No: S055745



Part: RB8813152000

Job No: 175103

Serial No/Batch: S055745

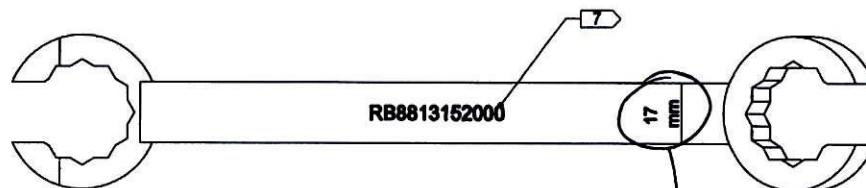
Revision: A

Inspector:

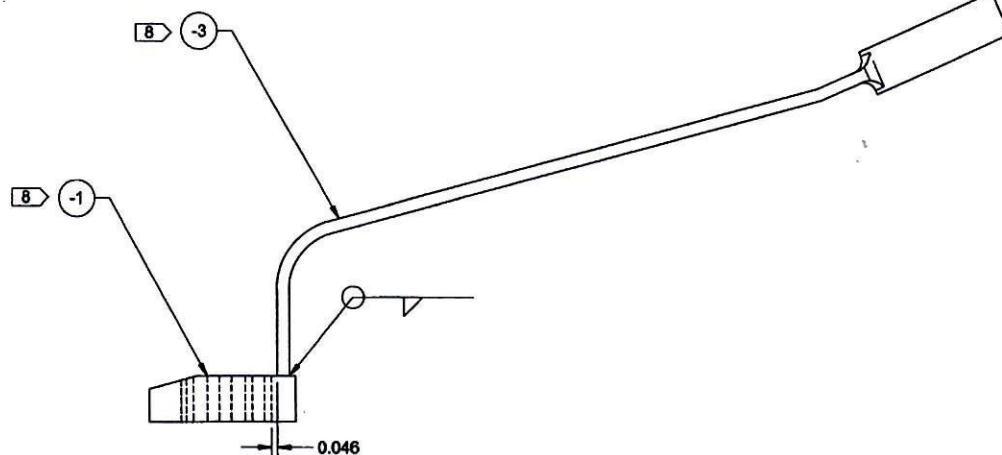
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/28/18

ITEM #	QTY	PART #	PART TITLE
-1	1	RB8813152000-1	19mm WRENCH
-3	1	RB8813152000-3	17mm WRENCH



REF ONLY
DON'T ENGRAVE



RB8813152000 SPECIAL WRENCH

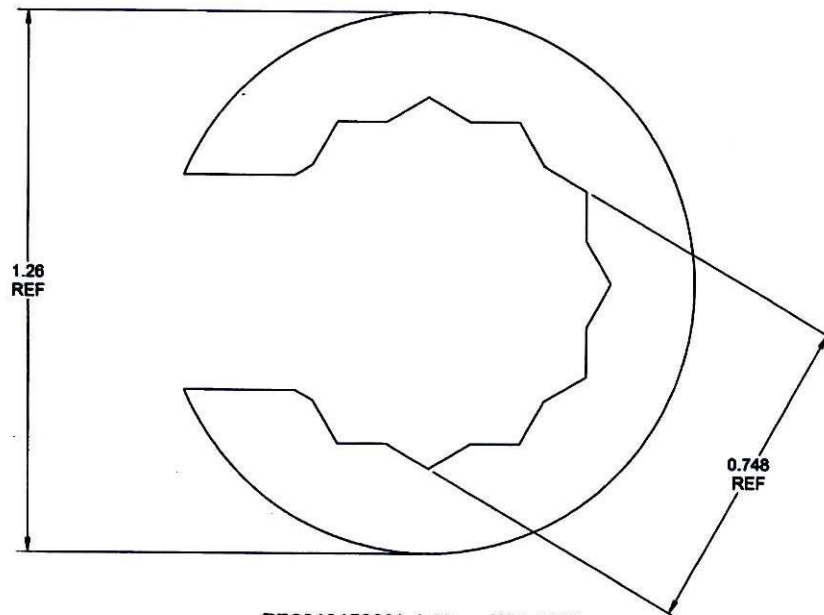
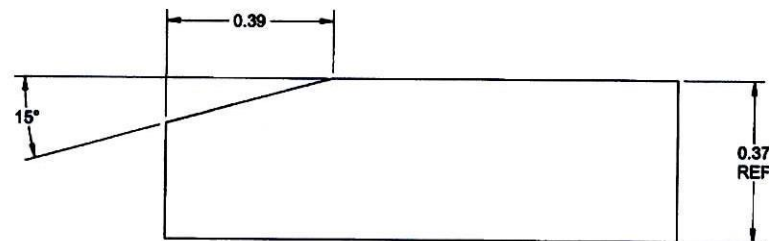
NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: NOT APPLICABLE / NOT REQUIRED
- 3) FINISH: ZINC PLATE (YELLOW) PER ASTM B633 TYPE 1 CLASS 2
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005" TO 0.010"
- 7) IDENTIFICATION: MACHINE ENGRAVE PER CAD MODEL AS SHOWN OR DOT MARK T/N AS SHOWN
- 8) CHROME MUST BE REMOVED ON ITEM -1 AND -3 PRIOR TO WELDING



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WORK ORDER
NO. 175103 ML5
1803-27

A	NEW ISSUE	18-701	ML
REV.	DESCRIPTION	ECN #	BY
DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML 03/20/2018		
CHECKED	VM 03/20/2018	TOOL PART #	REV. A
MFG. APPR.	DP 03/20/2018	RB8813152000	SHEET 1 OF 3
APPROVED	ML 03/28/2018	TITLE	SCALE
DATE 3/26/2018		SPECIAL WRENCH	NTS
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RB8813152000-1 19mm WRENCH

NOTES:

1) MATERIAL: McMaster#54855A37

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

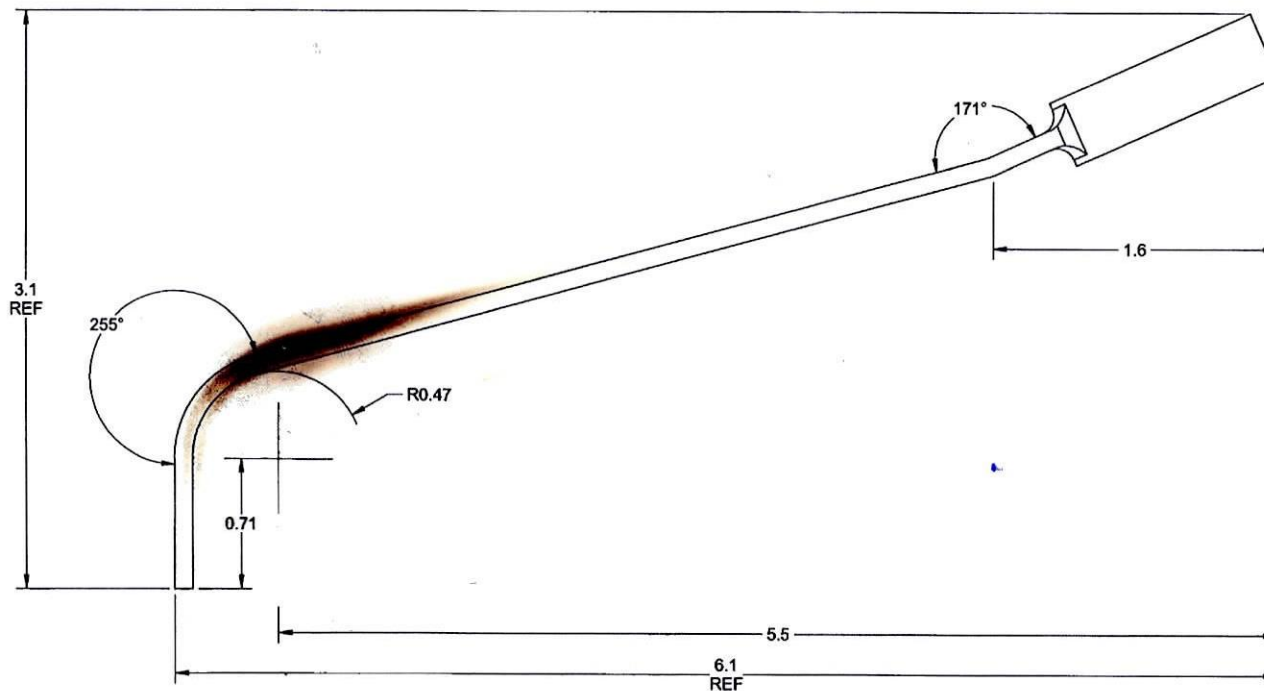
5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.005" TO 0.010"

7) IDENTIFICATION: N/A

8) CUT OFF WRENCH HANDLE AND GRIND 19mm HEAD SMOOTH, DISCARD REMAINDER OF WRENCH

DESIGN	ML	DART AEROSPACE LTD	
DRAWN	ML 03/20/2018	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM 03/20/2018	TOOL PART NUMBER	REV. A
MFG. APPR.	DP 03/20/2018	RB8813152000	SHEET 2 OF 3
APPROVED	ML 03/26/2018	DESCRIPTION	SCALE
DATE 3/26/2018		SPECIAL WRENCH	NTS
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RB8813152000-3 17mm WRENCH

NOTES:

1) MATERIAL: McMaster#54855A35

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°

X.XX = +/- 0.01" / +/- 0.5°

X.XXX = +/- 0.005" / +/- 0.1°

X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) BREAK SHARP EDGES: 0.005" TO 0.010"

7) IDENTIFICATION: N/A

8) CUT OFF 15 mm WRENCH HEAD AND DISCARD

DESIGN	ML	DART AEROSPACE LTD	
DRAWN	ML 03/20/2018	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM 03/20/2018	TOOL PART NUMBER	REV. A
MFG. APPR.	DP 03/20/2018	RB8813152000	SHEET 3 OF 3
APPROVED	ML 03/28/2018	DESCRIPTION	SCALE
DATE 3/26/2018		SPECIAL WRENCH	NTS
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER
PO039590

Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No:	PO039590
PO Date:	4/12/18
Due Date:	4/19/18
Purchase Order Revision:	
Revision Date:	
Ship-To Contact:	Tsimiklis, ChrisoulaPhone:
Via:	Ground
Pytm Terms:	Net 30
Freight Terms:	
Special Comments:	

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	170787	D5553-1	Bracket ISSUE P/O: _____ ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 C OF C IS REQUIRED	Firmed	4/17/18	11 pcs	0 pcs	11 pcs	\$10.90909/pcs	\$120.00
Line Item Note ** big rush - need asap **										
2	173097	RBST2854-9	Pin Issue P/O to Groupe Altech; PO _____ -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	4/17/18	4 pcs	0 pcs	4 pcs	\$30.00/pcs	\$120.00
3	175103	RB8813152000	Rear Bearing Tool -Issue P/O to Groupe Altech: P/O _____ -Zinc plate, ASTM B633 TYPE 2 SC2 -Color yellow -Certificate of Conformity is required	Firmed	4/17/18	3 pcs	0 pcs 3x	3 pcs 18/04/19	\$30.00/pcs	\$90.00

Grand Total:	\$330.00
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Order Notes

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

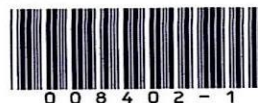
Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 4/16/18 11:05 AM dart.tsimiklis.chrisoula





Certificat de Conformité / Certificate of Compliance



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

008402- 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
18-Apr-2018		Curtis Anderson			039590			
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
3	RB8813152000 Rev.	RB8813152000 ZINC PLATE ASTM B633 TYPE 2 SC2 YELLOW	ZINC CH	3	3	0	0	0

Notes Additionnelles / Additional Notes

Épaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.